

Step 20/03

ASAP

Work Order ID 67384

Thursday, March 17, 2011 10:19:47 AM

Page 1

PRELIMINARY ISSUE

Item ID: D4330-3

Accept

Revision ID: PRELIM

Item Name: Airframe Bracket

Start Date: 3/17/2011 Start Qty: 1.00

Required Date: 3/18/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4330

PAT P06

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: PAT P06

Prog Rev: PAT P16

2-Deburr if necessary

110

-0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

- inspecto only
to P06 Dwg
8/10/17 @

11 03 17 ①

11 03 17 ①

Work Order ID 67384

Page 2

Thursday, March 17, 2011 10:19:47 AM

Item ID: D4330-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Airframe Bracket

Start Date: 3/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Form as per dwg
NC BRAKE

Memo

0.00

0.00

SS

16/03/18

①

Brake NC

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

→ Inspected to PAC

Dw only

8/10/18

Ⓢ

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

1 BR 11-3-18.

Work Order ID 67384

Thursday, March 17, 2011 10:19:47 AM



Page 3

Item ID: D4330-3 Accept

Revision ID: PRELIM

Item Name: Airframe Bracket

Start Date: 3/17/2011 Start Qty: 1.00

Required Date: 3/18/2011 Req'd Qty: 1.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|-----------------|--------------|---------------|---------------|------------------|----------------|
| 155 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum <i>M 115951</i> Memo POWDER COAT: Start Time: <i>10:40</i> Oven Temperature: <i>320°</i> Finish Time: <i>11:10</i> | 0.00 0.00 | | | | <i>1</i> | <i>62</i> | <i>11-3-18</i> | |
| 160 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | <i>54103/10</i> | | | | | |
| 170 Packaging Packaging | Identify as per dwg & Stock Location: Memo | 0.00 0.00 | | <i>RD1370</i> | | | | <i>11/3/10</i> | |

Work Order ID 67384

Page 4

Thursday, March 17, 2011 10:19:47 AM

Item ID: D4330-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Airframe Bracket

Start Date: 3/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

1103-18

POSITIVE RECALL
EFFECTIVE 110317 AUTH u
RELEASED _____ DATE _____

Picklist Print

Thursday, March 17, 2011 10:19:44 AM

Page 1

Work Order ID: 67384



Parent Item: D4330-3



Parent Item Name: Airframe Bracket

Start Date: 3/17/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.17 new issue DD verified by: EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.050 | | Purchased | No | | | 100 | sf | 196.8900 | 0.1402 | 0.147579 | | | |



6061-T6 .050 Sheet



MA 11-03-17

Location

Loc Qty

Loc Code

MAT

166.8

114799

38.8

114993

128

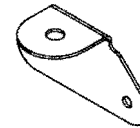
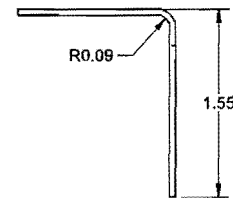
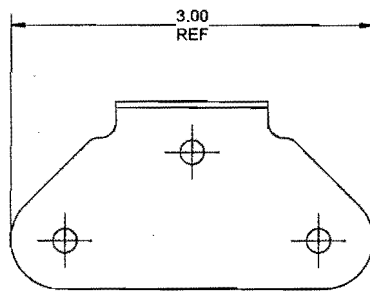
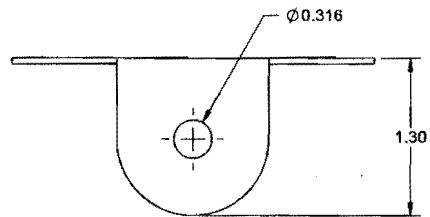
MAT21

30.09

113216

30.09

B112567



D4330-3 DOOR BRACKET

NOTES:

- 1) MATERIAL: MADE FROM D4330-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

PRELIMINARY ISSUE

DC 11.02.02

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | DC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | DC | DRAWING NO. | REV. PA6 |
| MFG. APPR. | | D4330 | SHEET 4 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BRACKET | NTS |
| DATE | 11.02.02 | <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

